

Date: Friday, 01/08/2008 3:30:38 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HEAD REST  
 Job Number : 40943  
 Estimate Number : 10423  
 P.O. Number :  
 This Issue : 01/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 38999  
 Part Number : D33033  
 Drawing Number : D3303 REV. B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 20/08/2008 Qty: 30 Um: Each  
 Written By :  
 Checked & Approved By : JD 08.8.05  
 Comment : Est:A 04.09.07 New issue KJ/JLM  
 Est Rev:B 08-05-13 add DT9011 jig DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.3135 sf(s)/Unit Total : 9.4059 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040) Batch: ~~106272~~ 106272 B 8-8-14

(33)

2.0 WATER JET FLOW WATER JET



B  
B

B 8-8-14



Comment: FLOW WATER JET

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-8-14



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



*[Signature]* 1060810 (33)



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1- Deburr B 8-8-14  
 2- C'sink nut plate holes as per Dwg D3303  
 3-polish waterjet marks

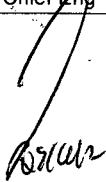
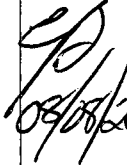


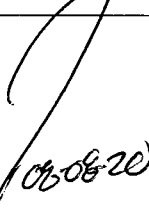
*[Signature]* 1060810 (32)

PTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3303-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>40943</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/20	5	1 holey countersink was too deep at the net-up		Swap & test key	 08/08/20	 08/08/19		 08/08/20

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:30:38 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 40943

Part Number: D33033

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3303 to fit DT9011

SD 08/07/20

(32)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20

countes

(32)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF 08-08-21

(32)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

08-08-21

(32)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 08-08-21

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21

Job Completion



mf 08-08-21

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	40943
<b>Description: Head Rest</b>		<b>Part Number:</b>	D3303-3
<b>Inspection Dwg: D3303</b>	<b>Rev: B</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

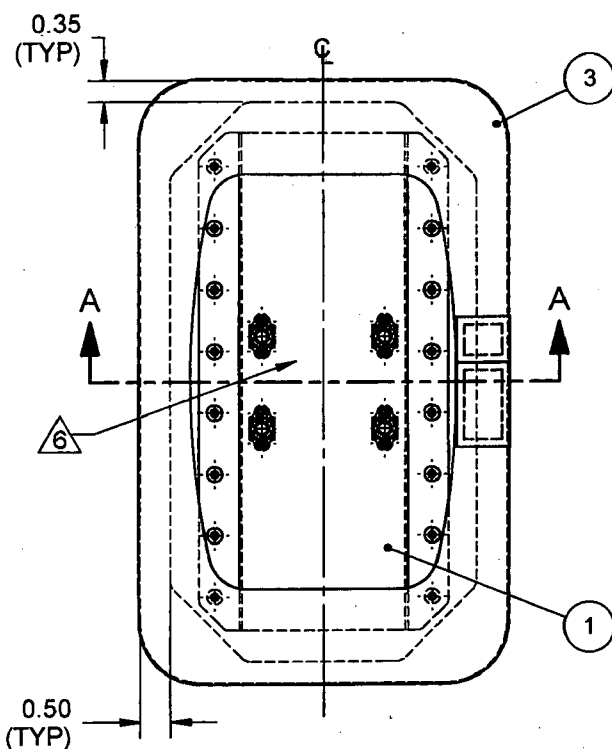
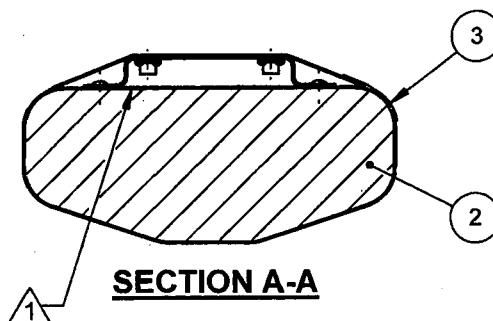
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.850	+/-0.010	4.854	X			
4.330	+/-0.005	4.334	X			
0.550	+/-0.010	.555	X			
0.260	+/-0.010	.260	X			
3.300	+/-0.010	3.298	X			
1.500	+/-0.005	1.498	X			
0.250	+/-0.005	.250	X			
Ø0.219	+0.005/-0.000	.221	X			
Ø0.098	+0.005/-0.000	.100	X			
Ø0.128	+0.005/-0.000	.130	X			
R0.12	+/-0.030	.12	X			
2.000	+/-0.005	2.001	X			
1.425	+/-0.010	1.430	X			
8.100	+/-0.010	8.105	X			
1.000	+/-0.005	1.000	X			
0.040	+/-0.010	.038	X			

<b>Measured by:</b>	RB	<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>	8-2-18	<b>Date:</b>	11/08/18	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue	KJ/JLM	
B	08.05.07	Dimensions updated per Dwg Rev B	KJ/DD	

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 1 OF 4
DATE <b>06.08.17</b>	TITLE <b>HEAD REST</b>	SCALE 1:3	
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	

**RELEASED***dc 09.19***D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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WITHOUT NOTICE  
WORK ORDER  
NO. 40943

**NOTES:**

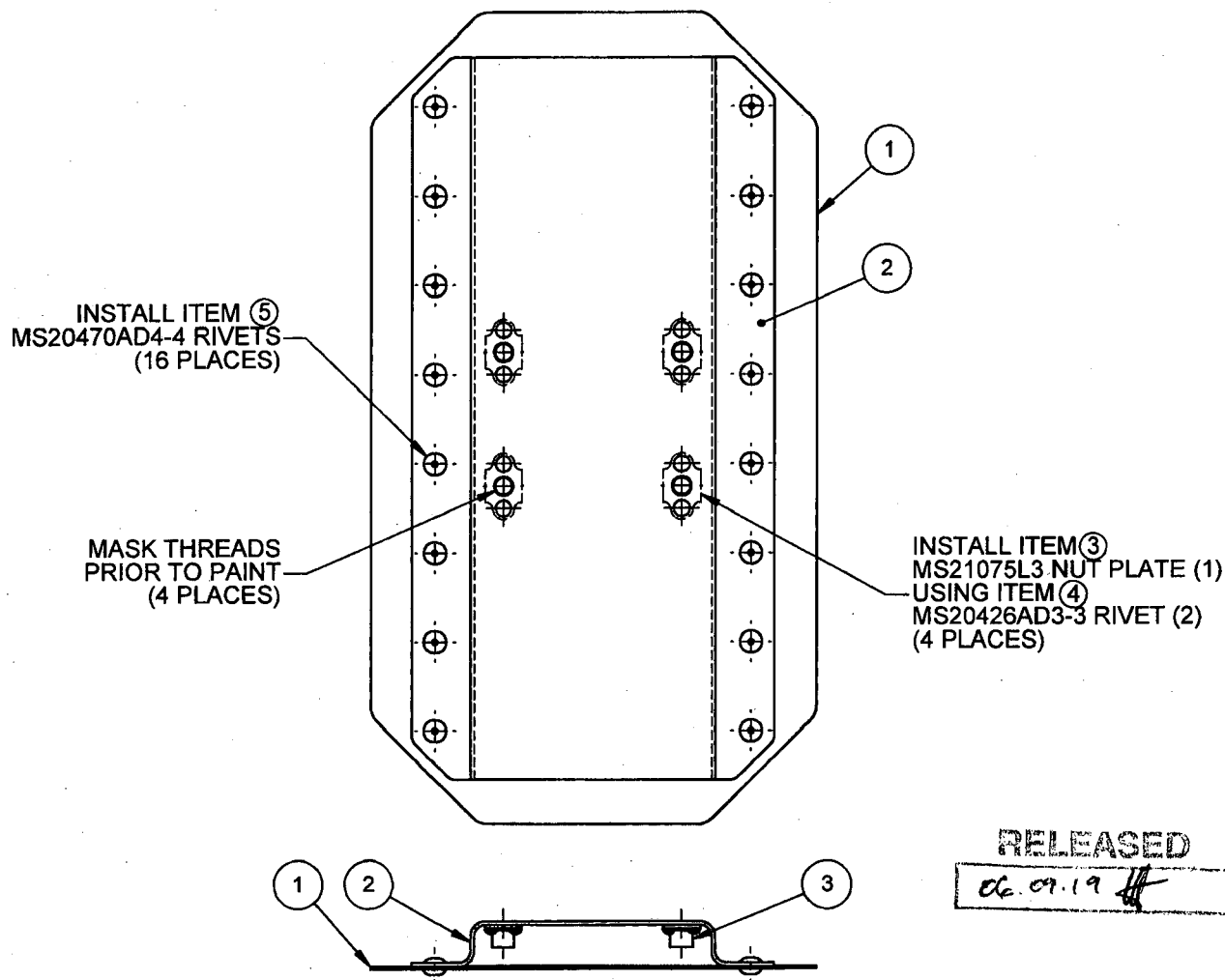
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 2 OF 4
DATE <b>06.08.17</b>		TITLE <b>HEAD REST</b>	SCALE 1:2



RELEASED  
06.09.19 *[Signature]*

**D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

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NO. 40943

**NOTES:**

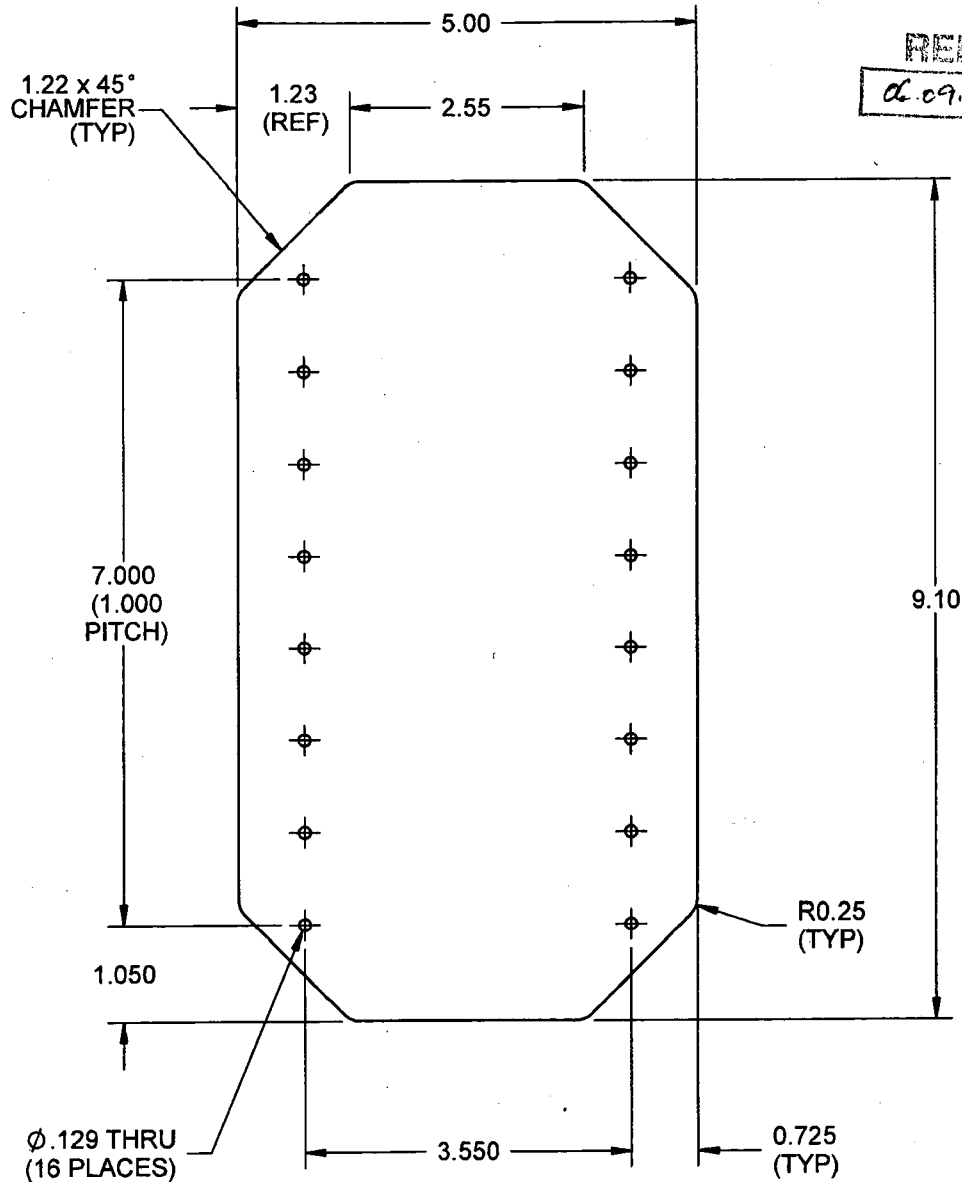
- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4. NO. *40943*
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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WORK ORDER  
*40943*

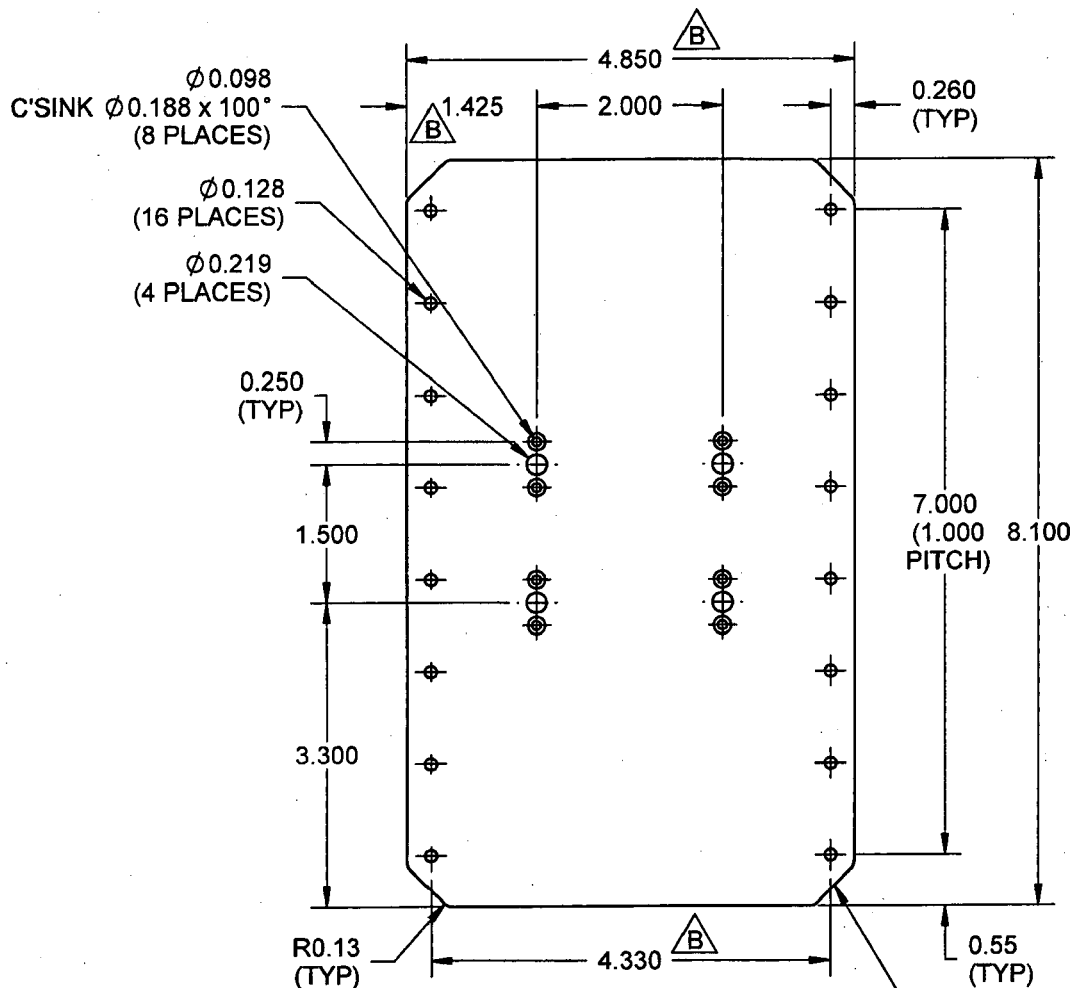
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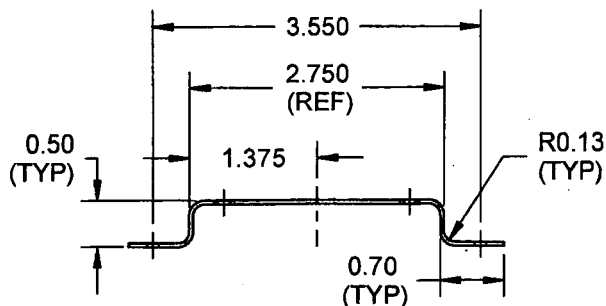
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 4 OF 4
DATE <b>06.08.17</b>		TITLE <b>HEAD REST</b>	SCALE 1:2

**D3303-3F BRACKET FLAT PATTERN**

RELEASED  
06-09-19

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NO. 40943

**D3303-3 BRACKET BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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